

Work Order ID 154329

Thursday, December 08, 2016 11:15:34 AM

154329

Page 1

Item ID: D4314-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Shim

Start Date: 12/5/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/8/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: DEC 09 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4314	A								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.09

FLOW CNC Waterjet

1-Cut as per Dwg D4314

Dwg Rev: AProg Rev: A

2-Debur if necessary

(10)

DC 11/2/12/18

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

(10)

DC 11/2/12/18

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.03

Quality Control

(10)

11-12-19

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

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Page 2

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SPC (Y/N): _____

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Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Small Fab

Small Fab

0.00

Memo

0.01

COUNTER SINK AS PER DWG

Small Fab

10x

DAS
36
9-89
16/12/20

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.03

10 16.12.20

DAS
9
9-89

160

160

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.03

(10) 2016/12/21
BEB

DQA: _____ Date: _____



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		OTHER : ☐							

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Page 3

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Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.01

Quality Control

⑩ 16-12-22

DAS
9
9-89

180

Identify as per dwg & Stock Location: 81091 0.00

180

Packaging

Memo

0.01

Packaging

10 JAN 03 2017

DAS
26
9-89

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.13

Quality Control

DAS
21
9-89

JAN 06 2017

DAS
21
9-89

JAN 03 2017

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WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
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Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Picklist Print

Thursday, December 08, 2016 11:15:33 AM

Page 1

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154329

Parent Item: D4314-3

D4314-3

Parent Item Name: Shim

Start Date: 12/5/2016

Required Date: 12/8/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.188		Purchased	No			100	sf	9.7300	0.0194	0.163369			

M6061T6S 188

6061-T6 .188 Sheet

on 12/12/18

Location

Loc Qty

Loc Code

MAT020

9.73

m129146

9.73

.2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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		OTHER : ☐			

DQA: _____ Date: _____

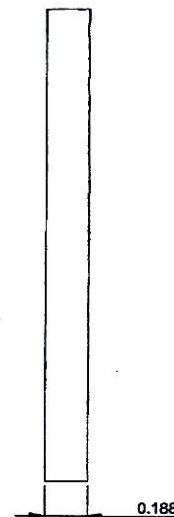
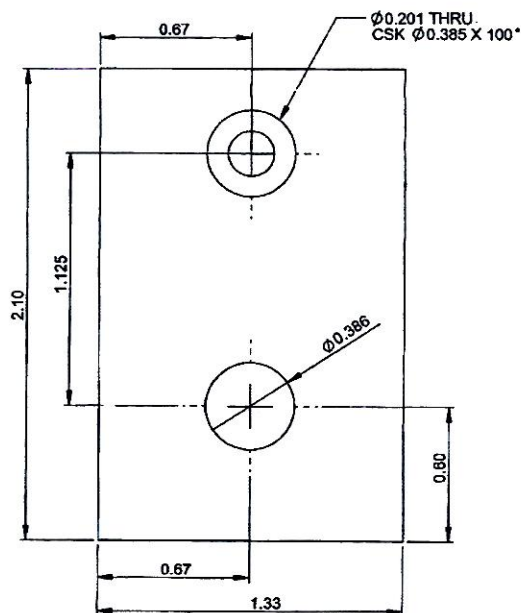
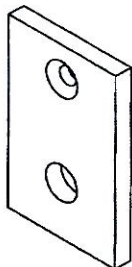


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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154329 MJS
1612-09

D4314-3 SHIM

RELEASED
2011-02-01
WJ

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.188)
OR
ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11
AMS 4025 OR ASTM B209 (REF DART SPEC M6061T6S.188)
OR
ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A-250/8
AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.188)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	WJ	D4314	SHEET 2 OF 2
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	SHIM	NTS
DATE	11.01.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RELEASED BY THE EXPRESS PERMISSION ONLY. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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